

Date: Wednesday, 1/23/2008 11:37:32 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HINGE BRACKET
Job Number : 36925	
Estimate Number : 10348	
P.O. Number :	Part Number : D28581
This Issue : 1/23/2008 S.O. No. :	Drawing Number : D2858 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 34310	Material :
Written By :	Due Date : 2/20/2008 Qty: 24 Um: Each
Checked & Approved By : <u>08 01 23</u>	
Comment : Est C 00.06.22 Removed P/O for powder coat EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1500X01250	6061-T6 Bar 1.5" x 1.25"
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Comment: Qty: 0.1767 f(s)/Unit Total: 4.2412 f(s)
 Material: 1.50" X 1.25"
 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8)
 (M6061T6B15001250)
 Batch M101694 X 12
M104183 X 12

08/02/12

(24)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks 6.02"
 Note: 1 Blank Makes 3 Parts

08/02/12

(24)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 1-Machine per folio D2858-
 2-Deburr as per Dwg D2858000

08/02

(PTO)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

08/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: 2858-1 PAR #: N/A Fault Category: Prod / Machine Part NCR: Yes No DQA: W Date: 08/02/22
 QA: N/C Closed: W Date: 08/02/22

NCR: <u>32925</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/02/13	3	3 pieces scrap, the wall .147 too thin of .026" R.C. poor tooling adjustment	<u>W</u> 08/02/22	Scrap and destroy and replace at HX B# M101624	<u>W</u> 08/02/24	<u>W</u> 08/02/24	<u>W</u> 08/02/22	<u>W</u> 08/02/24

NOTE: Date & initial all entries

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Drawing Name: HINGE BRACKET

Job Number: 36925

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

S.F 08/02/14

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.3

HL

08-02-14

(226)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

M107005

FL 08/02/14 (26)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-02-14

(226)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51

8/2/14 50

(242)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/02/08

(24)

Job Completion



2008/2/20

(24)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	36925
Description: Hinge Bracket		Part Number:	D2858-1
Inspection Dwg: D2858 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.171	+0.005/-0.001	Ø0.175	—			
Ø0.400	+0.006/-0.001	Ø0.400	—			
R0.125	+/-0.010	R.025	—			
0.328	+/-0.010	0.329	—			
0.820	+/-0.005	0.819	—			
1.476	+/-0.010	1.476	—			
0.342	+/-0.010	0.342	—			
0.875	+/-0.005	0.875	—			
1.56	+/-0.030	1.575	—			
0.147	+/-0.010	0.147	—			
0.717	+/-0.010	0.723	—			
0.697	+/-0.010	0.692	—			
0.229	+/-0.010	0.237	—			
R0.125	+/-0.010	R.125	—			
R0.063	+/-0.010	R.063	—			
0.063	+/-0.010	0.064	—			
0.126	+/-0.010	0.126	—			
0.630	+/-0.010	0.629	—			
R0.354	+/-0.010	R0.354	—			
0.965	+/-0.010	0.969	—			
Ø0.166	+0.005/-0.001	Ø0.167	—			
R0.125	+/-0.010	R.125	—			
32.7°	+/-0.5°	32.7°	—			

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	08/02/13	Date:	08-02-13	Date:	N/A

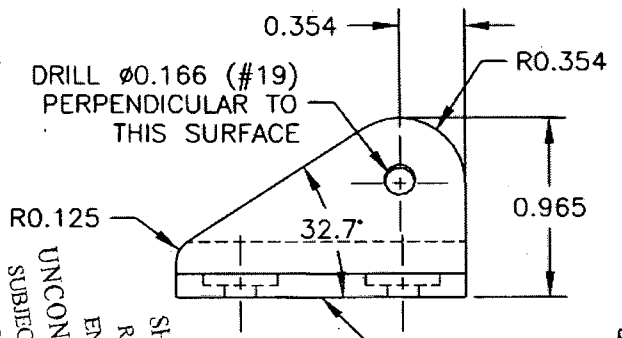
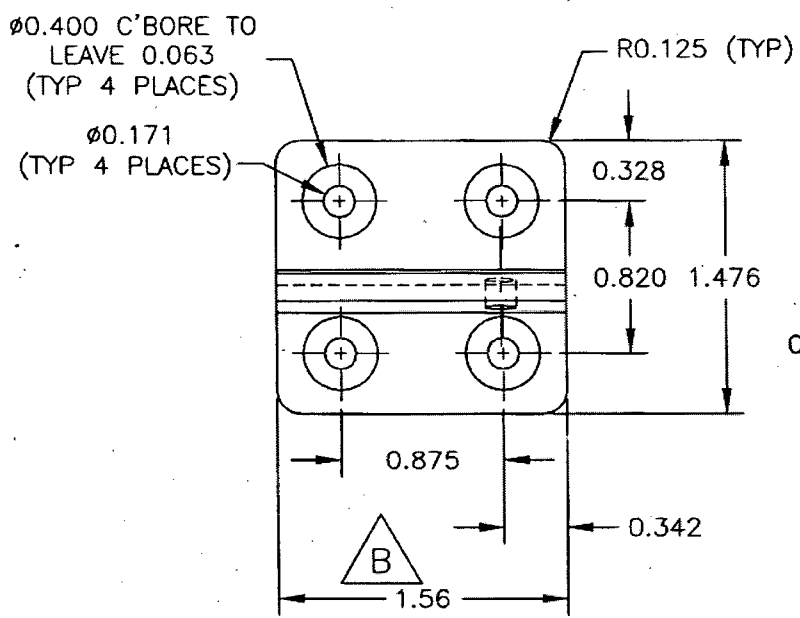
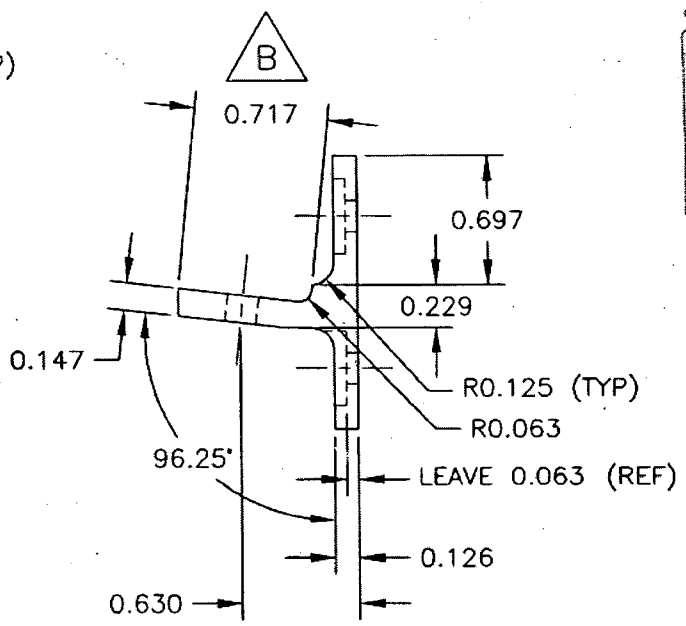
Rev	Date	Change	Revised by	Approved
A	07.10.30	New Issue	KJ/EC/DD	<i>[Signature]</i>

DART



RELEASED
99.02.09 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>KE</i>	APPROVED <i>KE</i>	HAWKESBURY, ONTARIO, CANADA
DATE 99.02.28	DRAWING NO. D2858	REV. B
	TITLE HINGE BRACKET	SHEET 1 OF 1
		SCALE 1:1
A	98.12.14	NEW ISSUE
B	99.02.28	0.717 WAS 0.667, 1.56 WAS 1.559



ENGRAVE P/N CENTERED ON
BASE 0.003 DEEP (0.010 MAX)

2858-1 SHOWN
2858-2 OPPOSITE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY
SUBJECT TO ATTENDANCE
WITHOUT NOTICE

WORK ORDER
NO. 36925